

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04489

SHEET 1 OF 1

DWG NO. 644,4100

REV: F

PREPARED BY: J. BECKER

DATE: 04/08/14

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: UPDATE NOTE 4, FINISH SPECIFICATION.

NOTES:

1. IDENTIFY ALL PARTS IN ACCORDANCE WITH MPP-120

2. MATERIAL: 2024-T3 ALUMINUM

3. MATERIAL: 6061-T6 ALUMINUM

4. FINISH IAW MPP-172 SECTION 2.1, SECTION 3.1, SECTION 4.1, SECTION 5.2.

5. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH, CUT ID HOLE USING 1/4" GASKET PUNCH

6. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH, CUT ID HOLE USING 5/16" GASKET PUNCH

7. DIMENSION VALUE HAS FINISH COATING OF 6-10 MIL (.006-.010) TAKEN INTO CONSIDERATION

8. ADD ADDITIONAL WASHER UNDERNEATH CASTLE NUTS IF NECESSARY.

9. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK.

SHEET 1, NOTES IS:

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04286

SHEET 1 OF 1

DWG NO. 644.4100

REV: F

PREPARED BY J. SOTO

DATE: 12/04/2013

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC

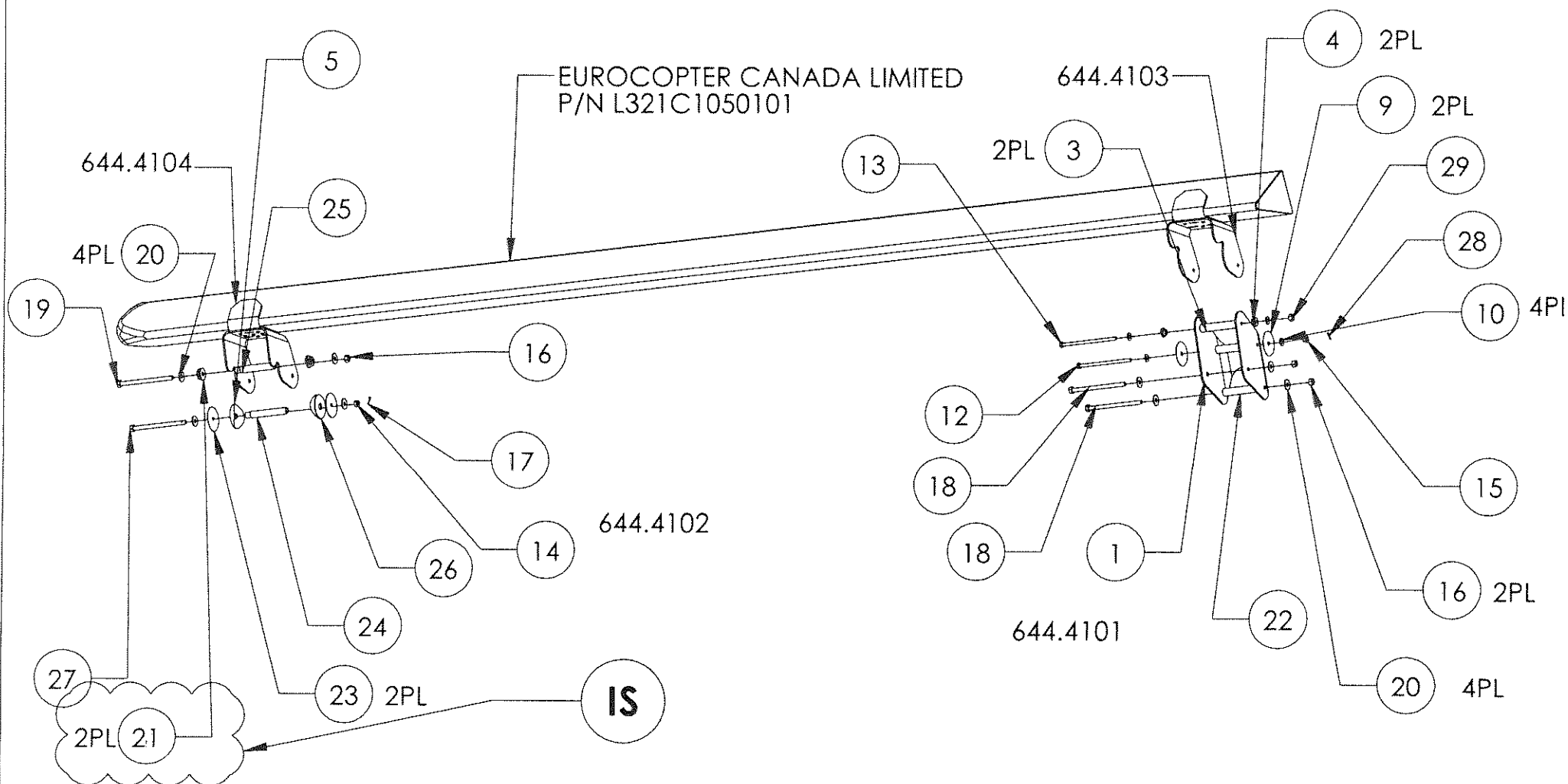
EFF. NEXT ORDER

TRANSACTION CODES (TC):
 A-ADD
 R-REVISE
 C-CREATE
 D-DELETE

REASON: REVISED F/N CALL OUT FROM 22 TO 21

ECR: 13-151

SHEET 1, ZONE D1 IS:



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

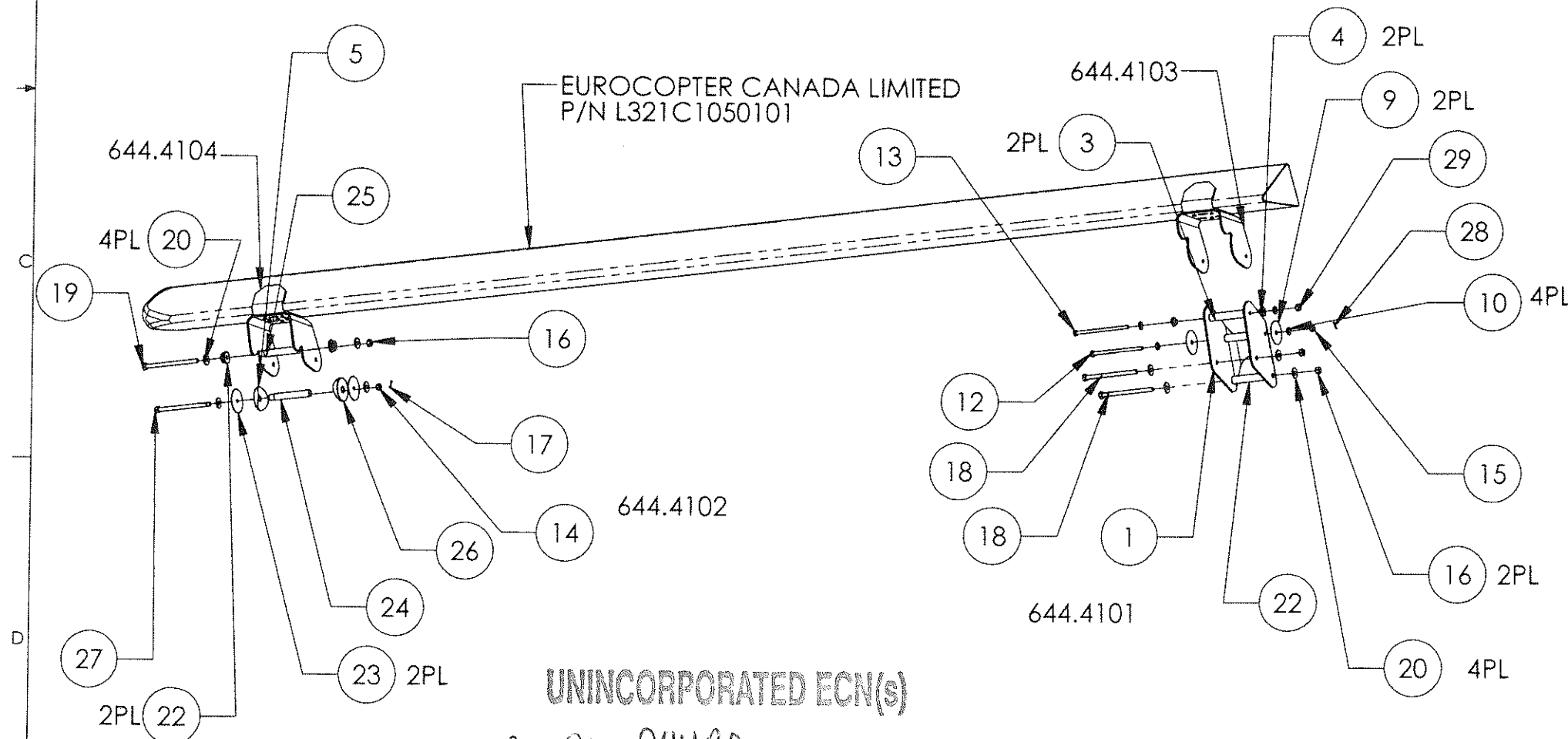
DER REVIEW REQUIRED

☐ YES ☒ NO

NOTES:

- | | | | |
|---|--|----------|---------|
| B | INCORPORATED ECN 01370, 01418, 01796, & 01838. | 05-21-07 | P. BRAV |
| C | INCORPORATED ECN 01908, 02326, 03022 | 12-14-10 | P. BRAV |
| D | INCORPORATED ECN 03111, 03113, 03208, & 03740. | 12-10-12 | P. BRAV |
| E | INCORPORATED ECN 03941 | 06-19-13 | P. BRAV |
| F | INCORPORATED ECN 04006 | 7-29-13 | P. BRAV |

644.4101



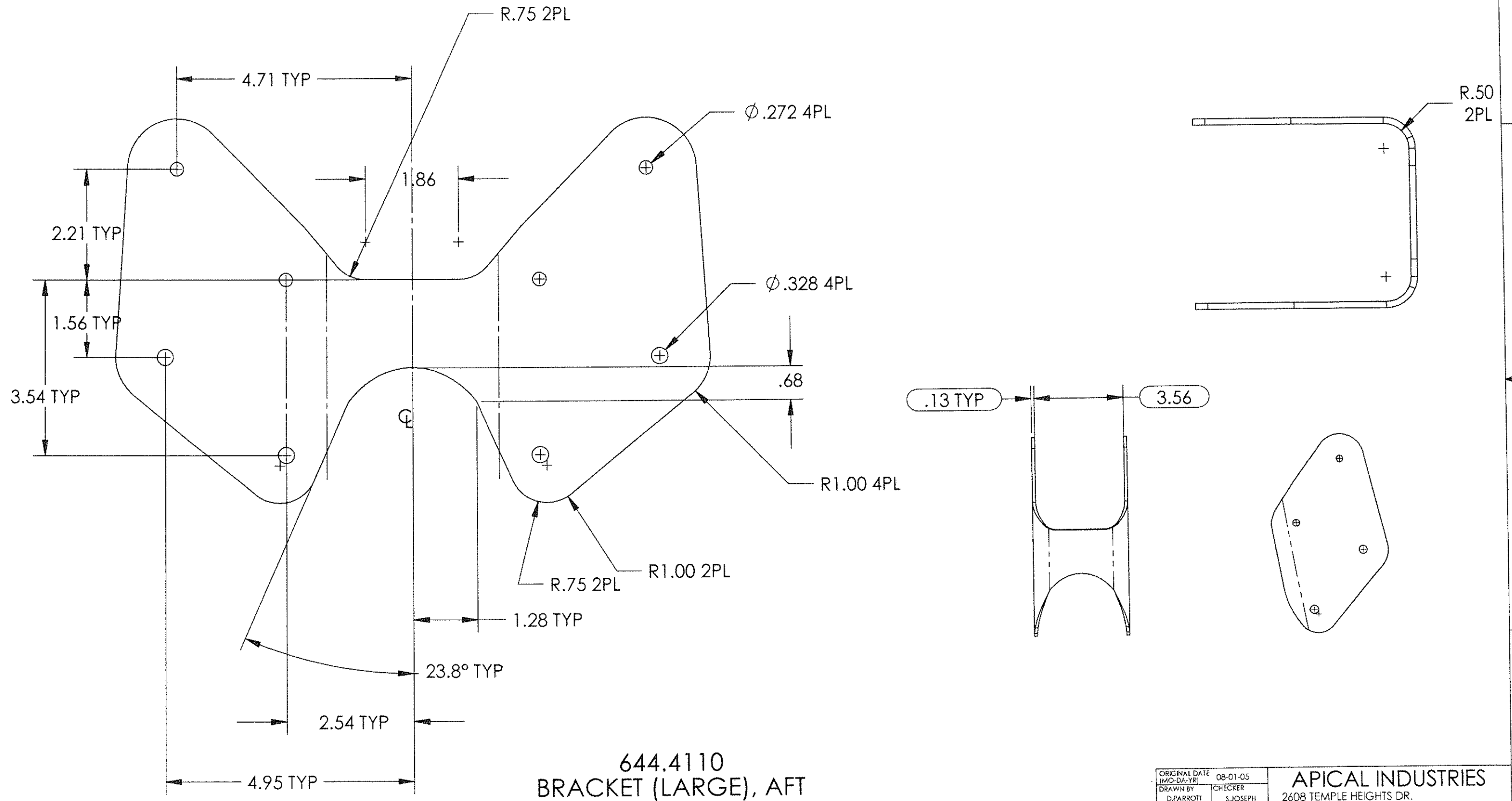
UNINCORPORATED ECN(S)

04286, 04489

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 01310, 01322, 01332, & 01357.	11-22-05	S. JOSEPH
B	INCORPORATED ECN 01370, 01418, 01796, & 01838.	05-21-07	P. BRAVO
C	INCORPORATED ECN 01908, 02326, 03022	12-14-10	P. BRAVO
D	INCORPORATED ECN 03111, 03113, 03208, & 03740.	12-10-12	P. BRAVO
E	INCORPORATED ECN 03941	06-19-13	P. BRAVO
F	INCORPORATED ECN 04006	7-29-13	P. BRAVO

			1	29	601.3273	LOCKNUT FULL	MS21044N4		
			1	28	601.2640	COTTER PIN	MS24665-132		
			1	27	601.2328	BOLT, HEX	AN5-45		
			1	26	644.4124	WASHER, PIVOT	$\frac{3}{4}$ $\frac{7}{8}$		
			1	25	644.4123	FWD CROSSTUBE BUSHING	$\frac{3}{4}$ $\frac{9}{16}$		
			1	24	644.4122	FWD CROSSTUBE BUSHING	$\frac{3}{4}$ $\frac{9}{16}$		
			2	23	644.4121	WASHER, NYLON	$\frac{6}{16}$		
			1	22	644.4120	SPACER, CROSS-TUBE	$\frac{3}{4}$ $\frac{1}{4}$		
			2	21	644.4119	SPACER, FWD STOP	$\frac{3}{4}$ $\frac{1}{4}$		
			4	4	20	601.2110	WASHER, FLAT THICK	NAS1149C 0563R	
			1	19	601.2250	BOLT, HEX	AN5-50		
			2	18	601.2249	BOLT, HEX	AN5-43A		
			1	17	601.3315	COTTER PIN	MS24665-210		
			1	2	16	601.3272	LOCKNUT FULL	MS21044N5	
			1	15	601.1435	NUT, HEX CASTLE FULL	AN310-4		
			1	14	601.3270	NUT, HEX CASTLE FULL	AN310-5		
			1	13	601.3407	BOLT, HEX	AN4-47A		
			1	12	601.2434	BOLT, HEX	AN4-45		
6	3			11	601.2326	RIVET, COUNTERSUNK	MS20426AD5-8		
				4	10	601.0863	WASHER, THICK	NAS1149C 0463R	
				2	9	644.4118	WASHER, NYLON	$\frac{5}{16}$	
1				8	644.4117	BRACKET, FWD PIVOT	$\frac{2}{4}$ $\frac{1}{4}$		
1				7	644.4116	BRACKET (SMALL), FWD	$\frac{2}{4}$ $\frac{1}{4}$		
	1			6	644.4115	BRACKET (SMALL), AFT	$\frac{2}{4}$ $\frac{1}{4}$		
		1		5	644.4114	WASHER, PIVOT	$\frac{3}{4}$ $\frac{1}{4}$		
			2	4	644.4113	SPACER, STOP	$\frac{3}{4}$ $\frac{1}{4}$		
			2	3	644.4112	SPACER	$\frac{3}{4}$ $\frac{1}{4}$		
	1			2	644.4111	BRACKET, AFT PIVOT	$\frac{2}{4}$ $\frac{1}{4}$		
		1	1	1	644.4110	BRACKET (LARGE), AFT	$\frac{2}{4}$ $\frac{1}{4}$		
		1			644.4104	FWD BRACKET ASSY			
			1		644.4103	AFT BRACKET ASSY			
					644.4102	PIVOT STEP ASSY			
					644.4101	PIVOT STEP ASSY			
4104	4103	4102	4101	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
QTY				PARTS LIST					
NEXT ASSY (S)				ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 PIVOT STEP ASSY			
644.1800				DRAWN BY D.PARROTT					CHECKER S.JOSEPH
				DRAWING APPROVAL S.JOSEPH 08-29-05					
				CONTRACT NO.					
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SIZE B CAGE CODE 07M26 DWG. NO. 644.4100 REV. F			
				SCALE: NONE		SHEET 1 OF 16			

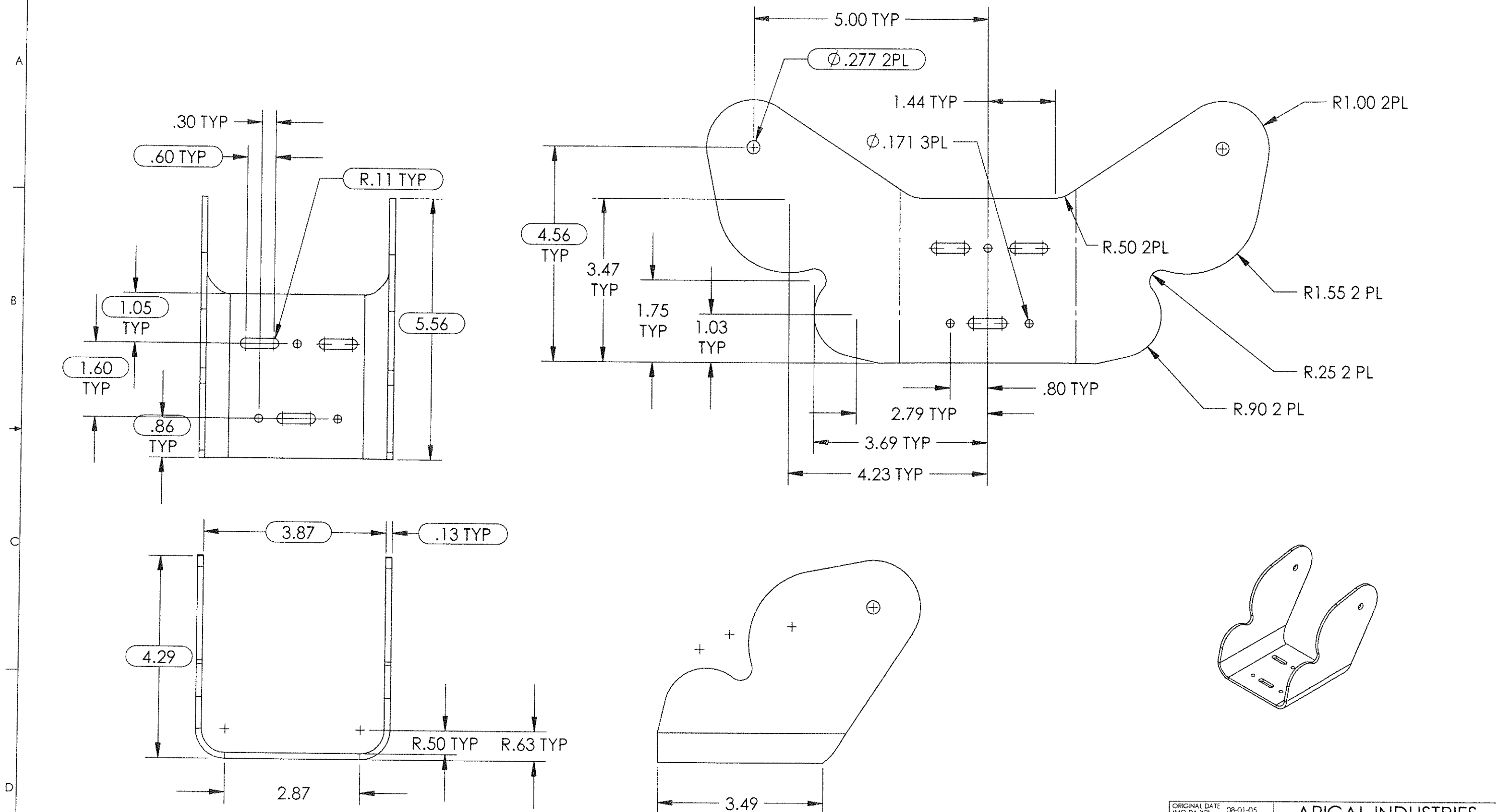
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644.4110
BRACKET (LARGE), AFT

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES	
DRAWN BY D.PARROTT	CHECKER S.JOSEPH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S.JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SIZE B	REV. F
		CAGE CODE 07MZ6	DWG. NO. 644.4100
		SCALE NONE	SHEET 2 OF 16

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644.4111
BRACKET, AFT PIVOT

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES	
DRAWN BY D. PARROTT	CHECKER S. JOSEPH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH 08-27-05		PIVOT STEP ASSY	
CONTRACT No.		SIZE B	REV. F
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		CAGE CODE 07M26	DWG. NO. 644.4100
		SCALE NONE	SHEET 3 OF 16

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A

B

C

D

3.54 $\triangle 7$

$\phi .51$
TYP

$\phi .63$

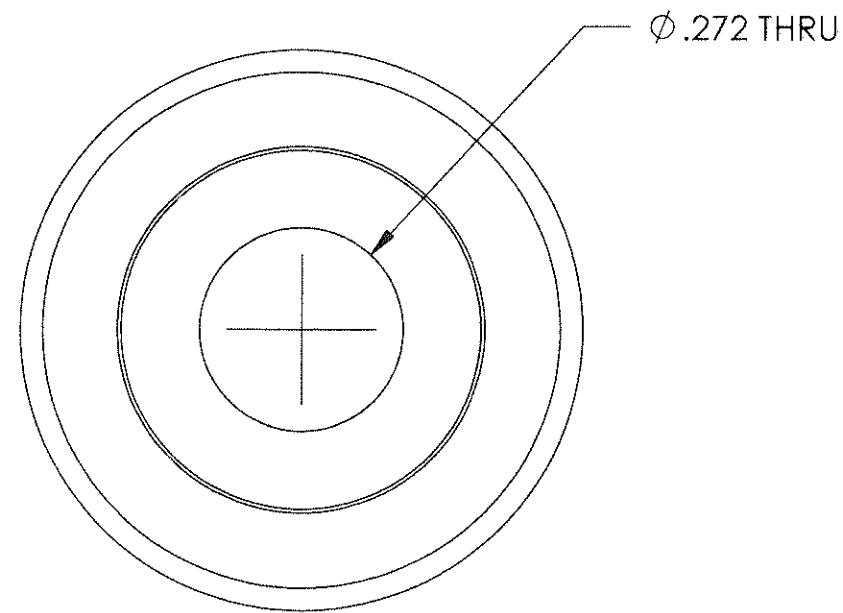
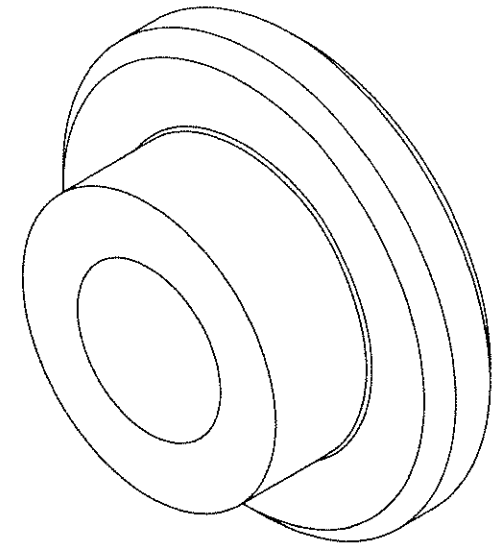
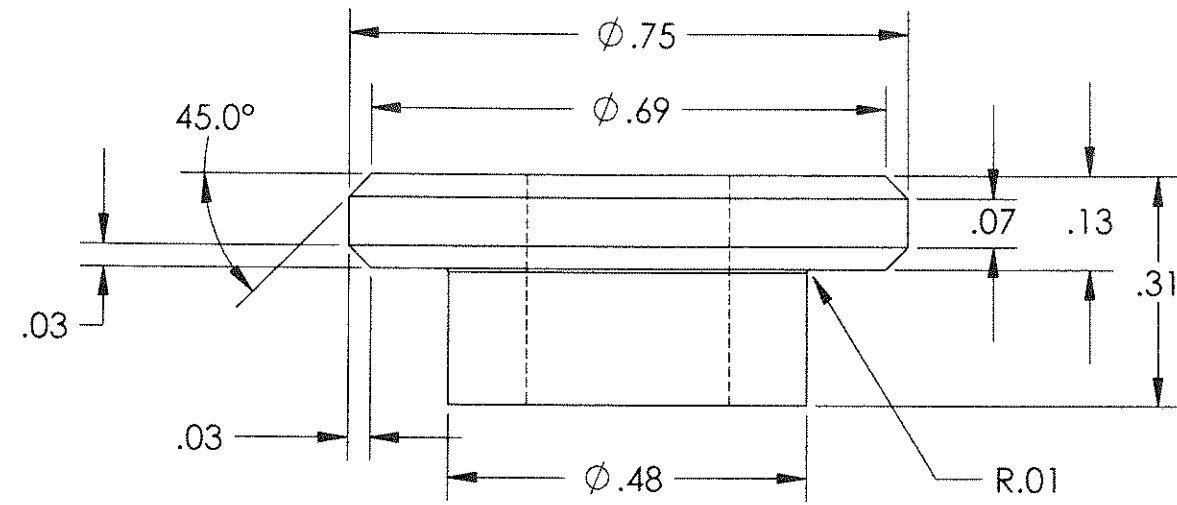
.06 X 45.0°

644.4112
SPACER

$\phi .272$ THRU

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWN BY D.PARROTI	CHECKER S.JOSEPH			
DRAWING APPROVAL S.JOSEPH 08-29-05		PIVOT STEP ASSY		
CONTRACT No.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SRT B	CAGE CODE 07MZ6	DWG. NO. 644.4100
		SCALE NONE		REV. F
		SHEET 4 OF 16		

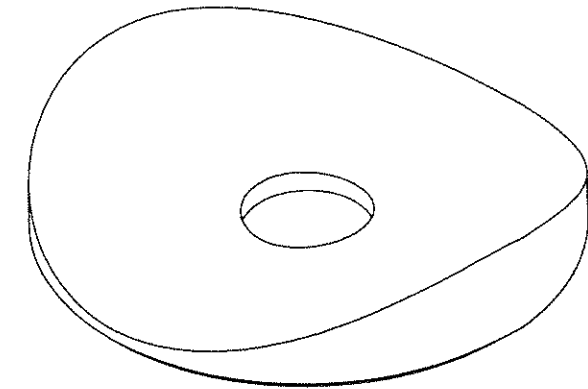
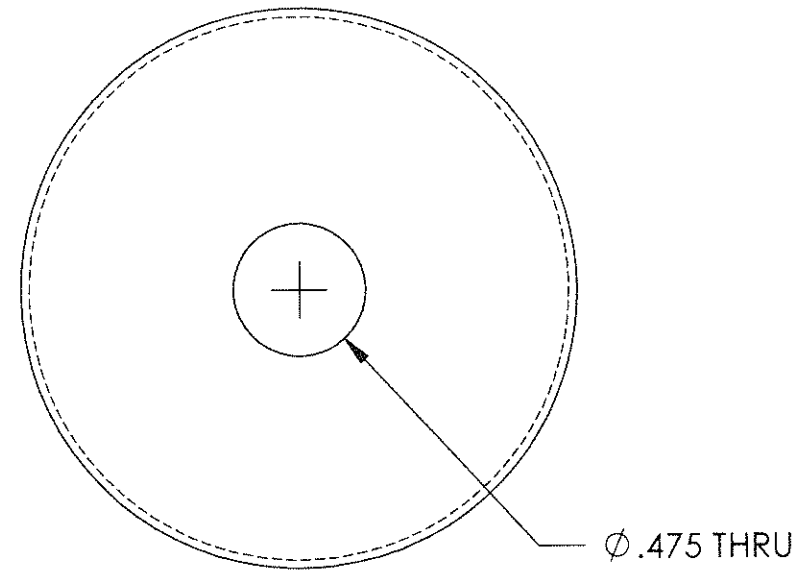
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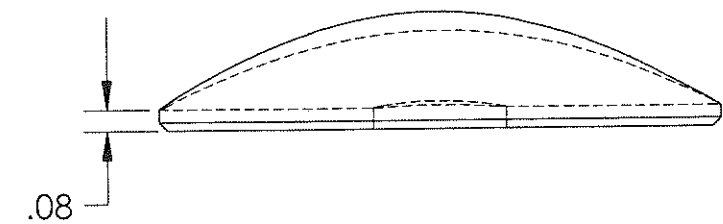
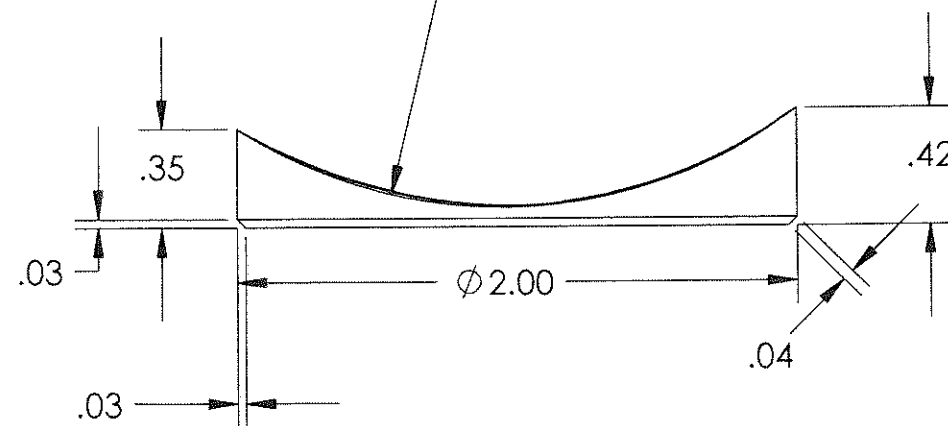
644.4113
SPACER, STOP

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES	
DRAWN BY D. PARROTT		CHECKER S. JOSEPH	
DRAWING APPROVAL S. JOSEPH 08-29-05		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT No.		PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°	SIZE B	CAGE CODE 07MZ6	DWG. NO. 644.4100
SCALE NONE		REV. F	
SHEET 5 OF 16			

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R1.75

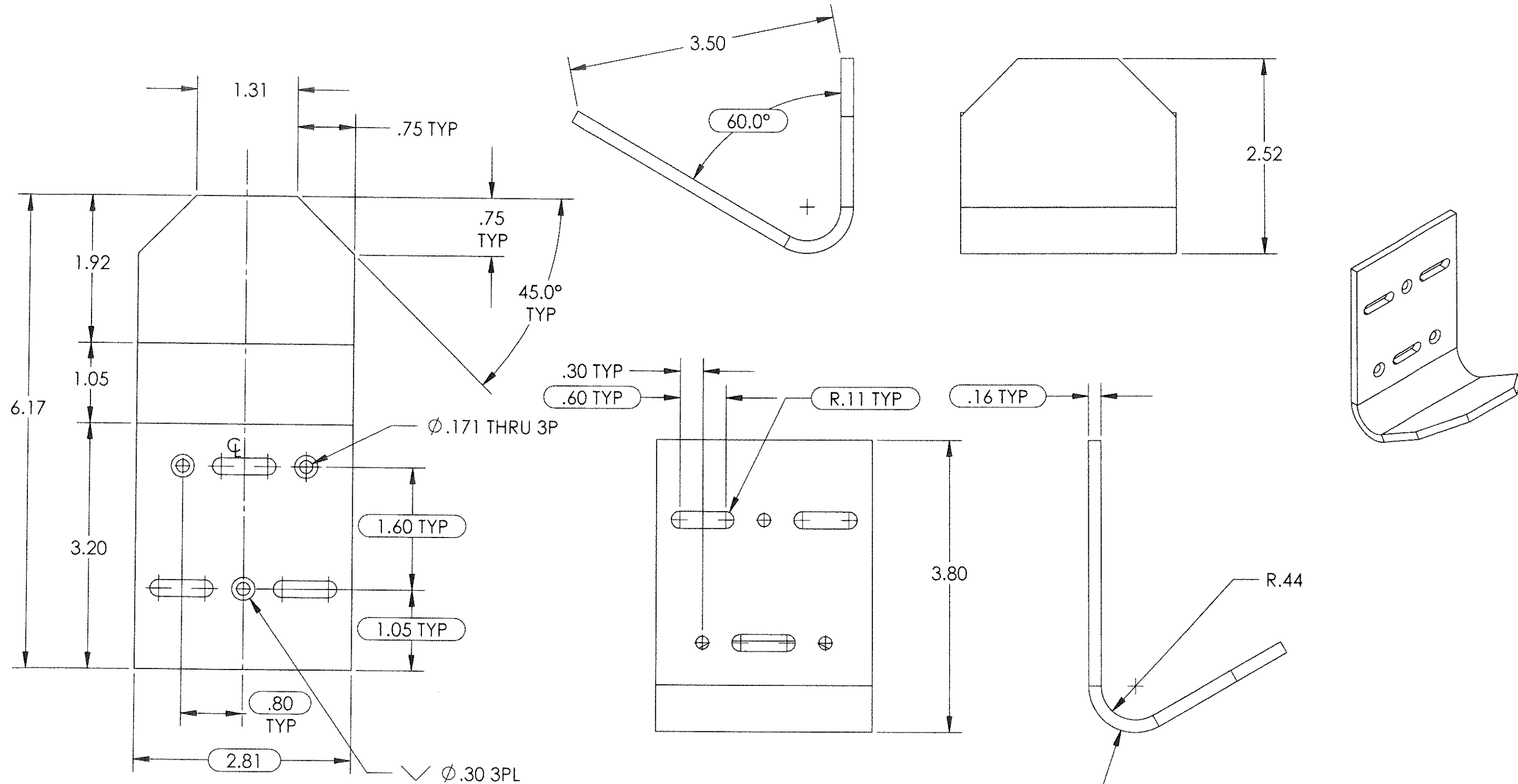


644.4114
WASHER, PIVOT

ORIGINAL DATE 08-01-05 (MO-DA-YR)		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D. PARROTT	CHECKER S. JOSEPH		
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.		SIZE B	REV. F
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		CAGE CODE 07MZ6	DWG. NO. 644.4100
		SCALE NONE	SHEET 6 OF 16

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A
B
C
D

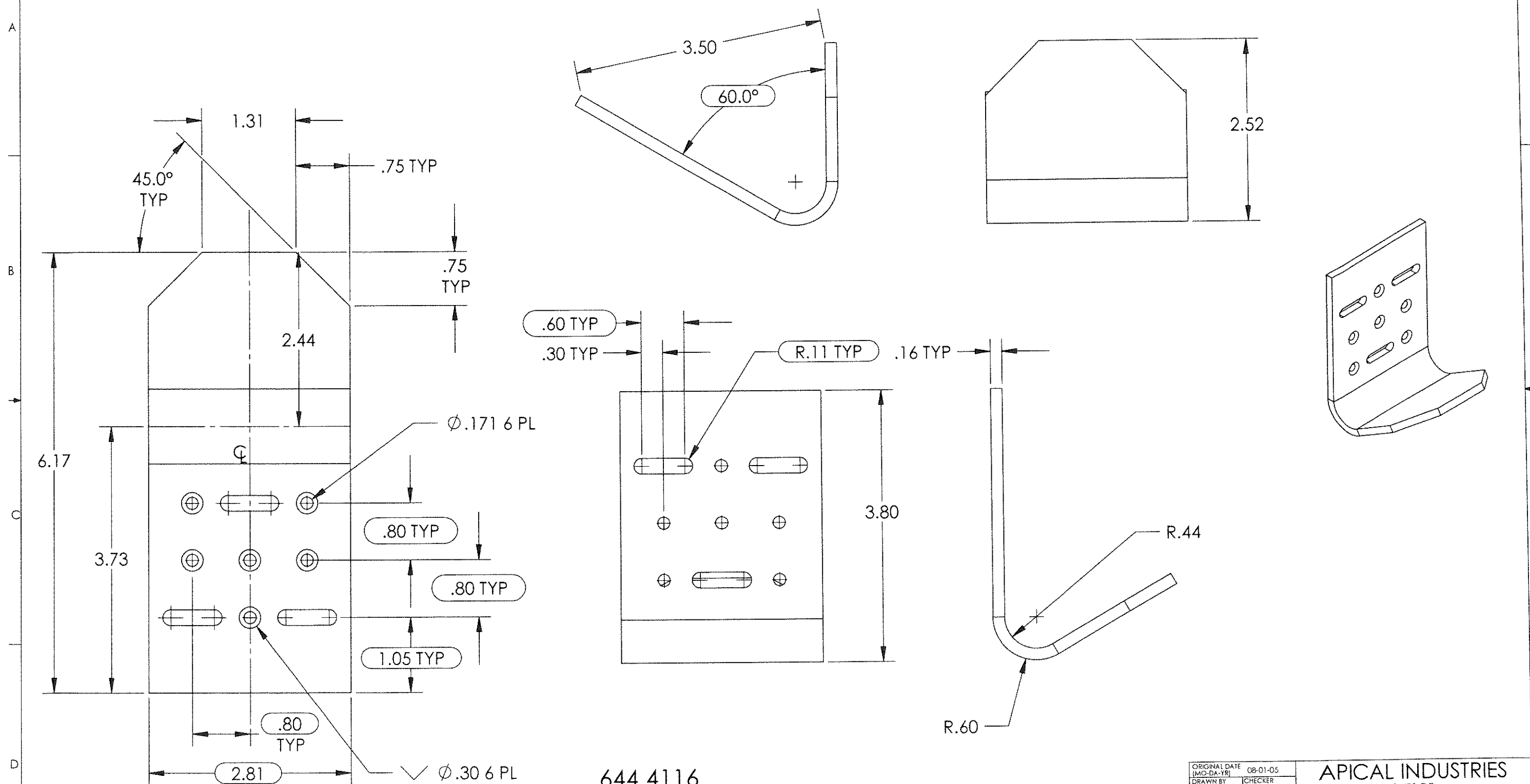


644.4115
BRACKET (SMALL), AFT

FLAT VIEW

ORIGINAL DATE 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D. PARROTT	CHECKER S. JOSEPH		
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ± .5°	
SIZE B	CAGE CODE 07M16	DWG. NO. 644.4100	REV. F
SCALE NONE		SHEET 7 OF 16	

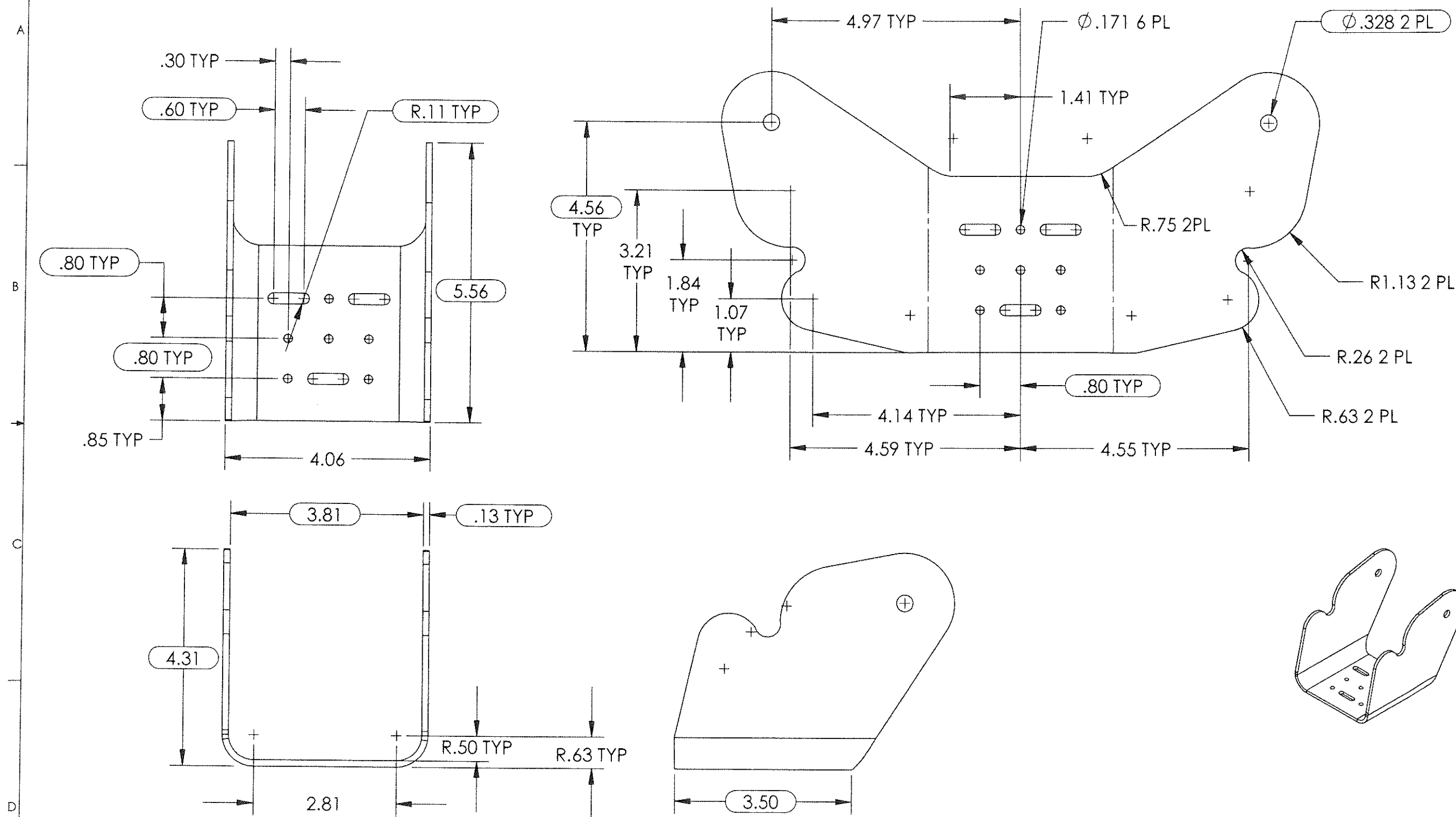
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644.4116
BRACKET (SMALL), FWD

ORIGINAL DATE (W/O-D/R)	08-01-05	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY	CHECKER D. PARROTT S. JOSEPH				
DRAWING APPROVAL S. JOSEPH 08-29-05					
CONTRACT NO.		PIVOT STEP ASSY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°					
SIZE B	CAGE CODE 07MZ6	DWG. NO. 644.4100	REV. F		
SCALE NONE			SHEET 8 OF 16		

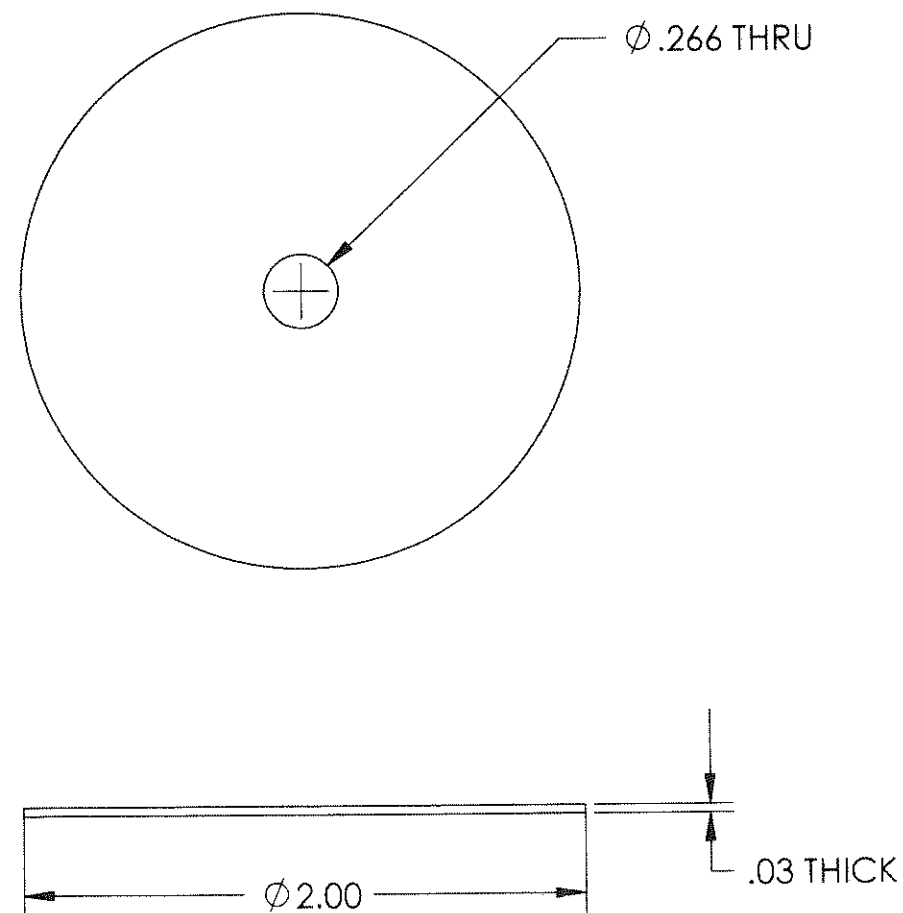
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644.4117
BRACKET, FWD PIVOT

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D.PARROTT	CHECKER S.JOSEPH		
DRAWING APPROVAL S.JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE B	REV. F
		CAGE CODE 07M26	DWG. NO. 644.4100
		SCALE NONE	SHEET 9 OF 16

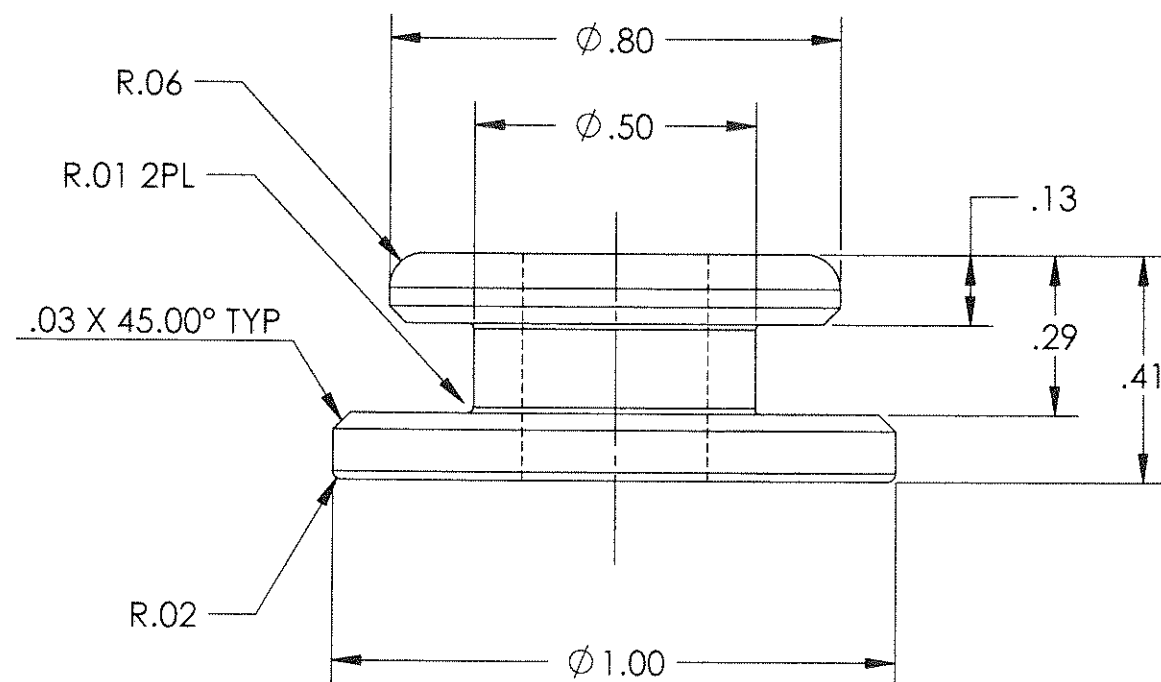
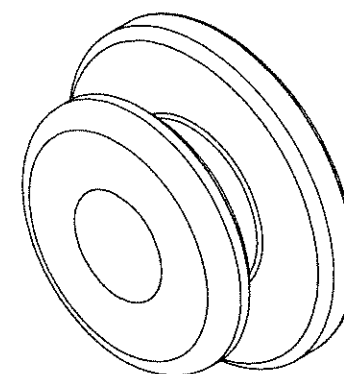
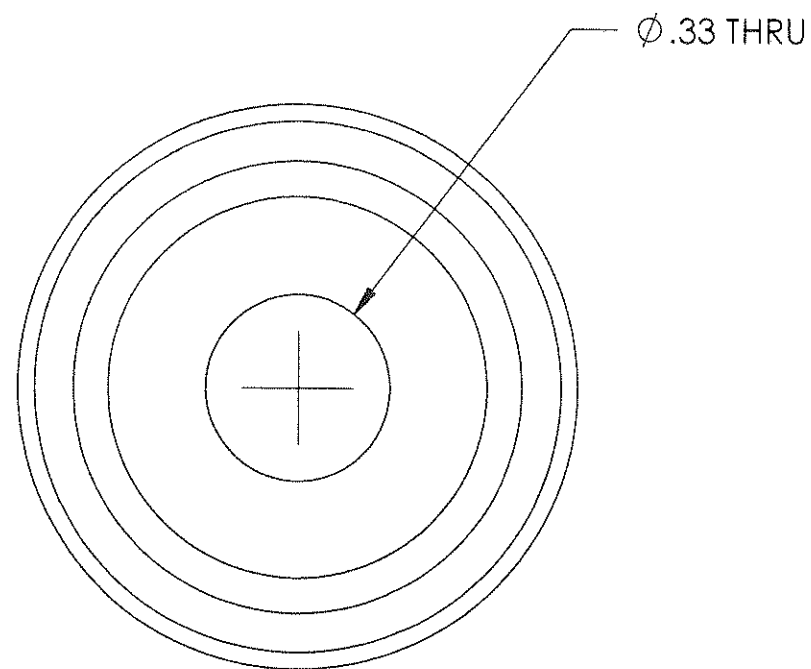
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644.4118
WASHER, NYLON

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D.PARROTT	CHECKER S.JOSEPH		
DRAWING APPROVAL S.JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SHEET B 07MZ6	REV. F
SCALE NONE		DWG. NO. 644.4100	SHEET 10 OF 16

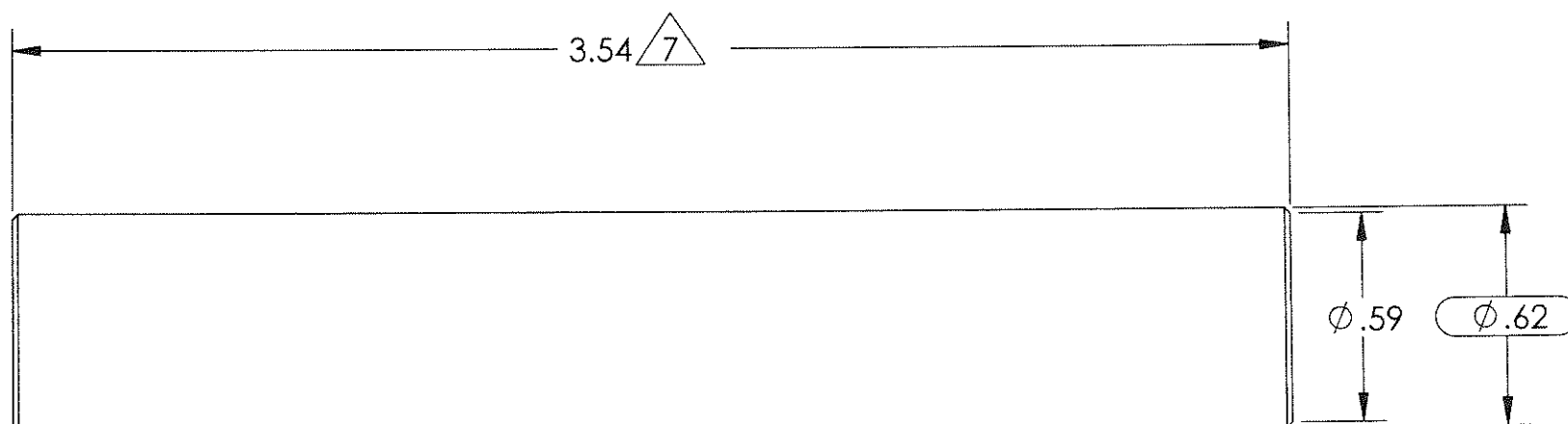
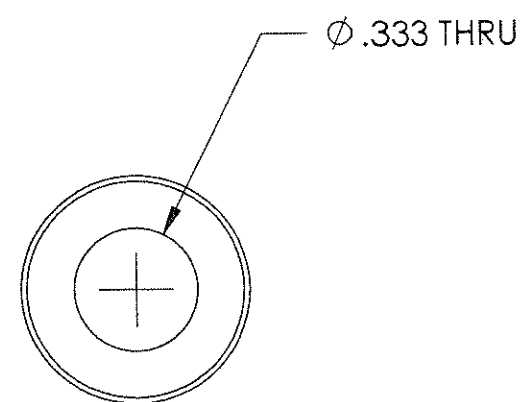
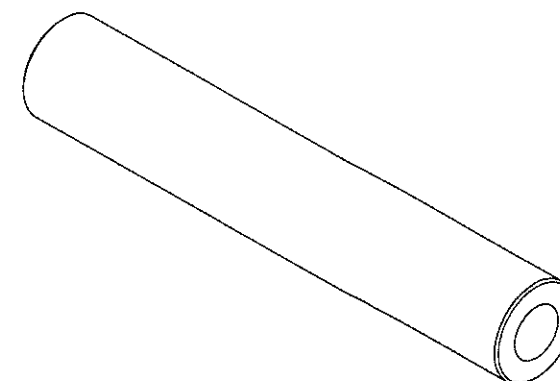
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644.4119
SPACER, FWD STOP

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY D. PARROTT	CHECKER S. JOSEPH				
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY			
CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE B	CAGE CODE 07M26	DWG. NO. 644.4100	REV. F
		SCALE NONE		SHEET 11 OF 16	

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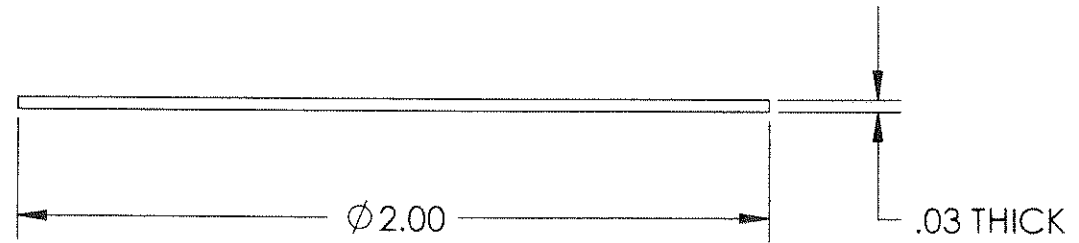
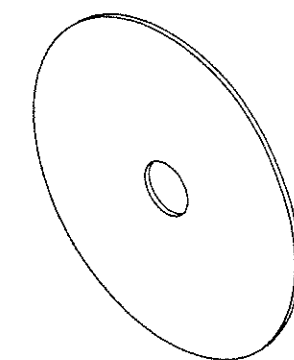
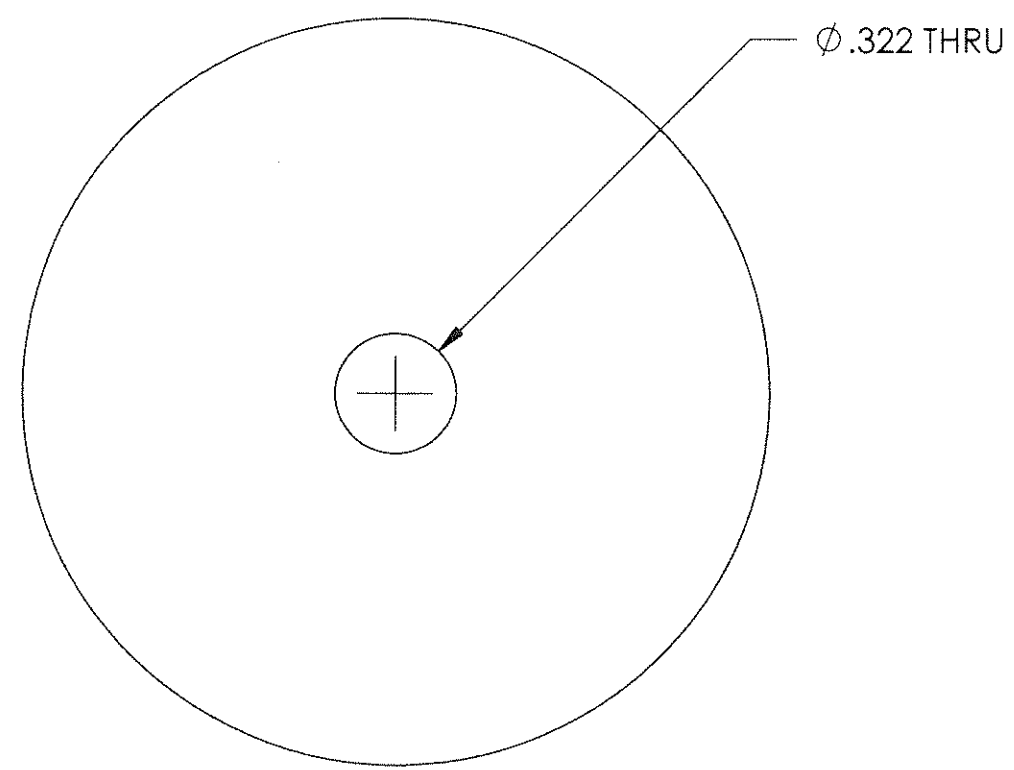


.02 X 45.00°

644.4120
SPACER, CROSS-TUBE

ORIGINAL DATE J-MO-DA-YR 08-01-05		APICAL INDUSTRIES	
DRAWN BY D. PARROTT		2608 TEMPLE HEIGHTS DR.	
CHECKER S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT No.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE B	CAGE CODE 07M26
		DWG. NO. 644.4100	REV. F
		SHEET 12 OF 16	

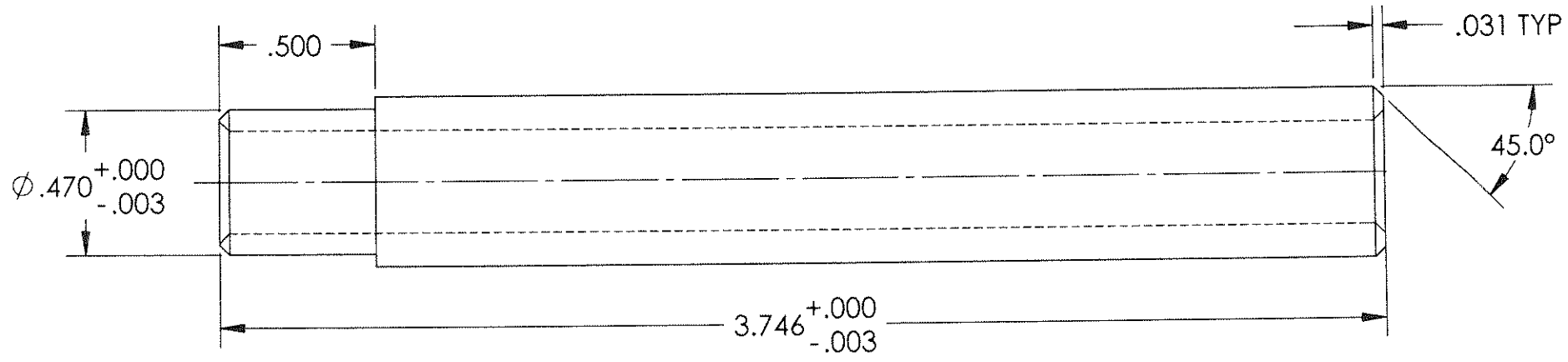
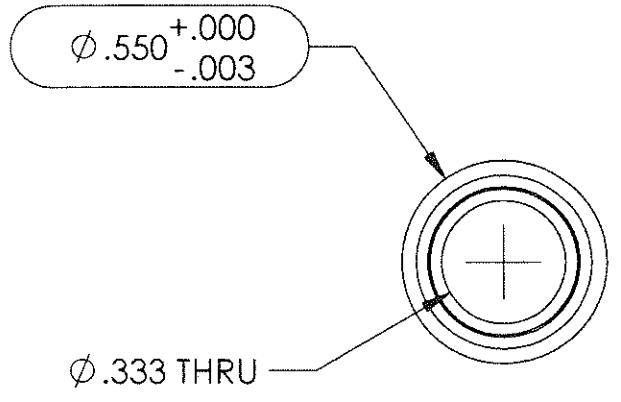
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644.4121
WASHER, NYLON

ORIGINAL DATE (MO-DA-YR) 08-01-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY D.PARROTT	CHECKER S.JOSEPH				
DRAWING APPROVAL S.JOSEPH 08-29-05		PIVOT STEP ASSY			
CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE	CAGE CODE	DWG. NO.	REV.
		B	07MZ6	644.4100	F
		SCALE NONE			

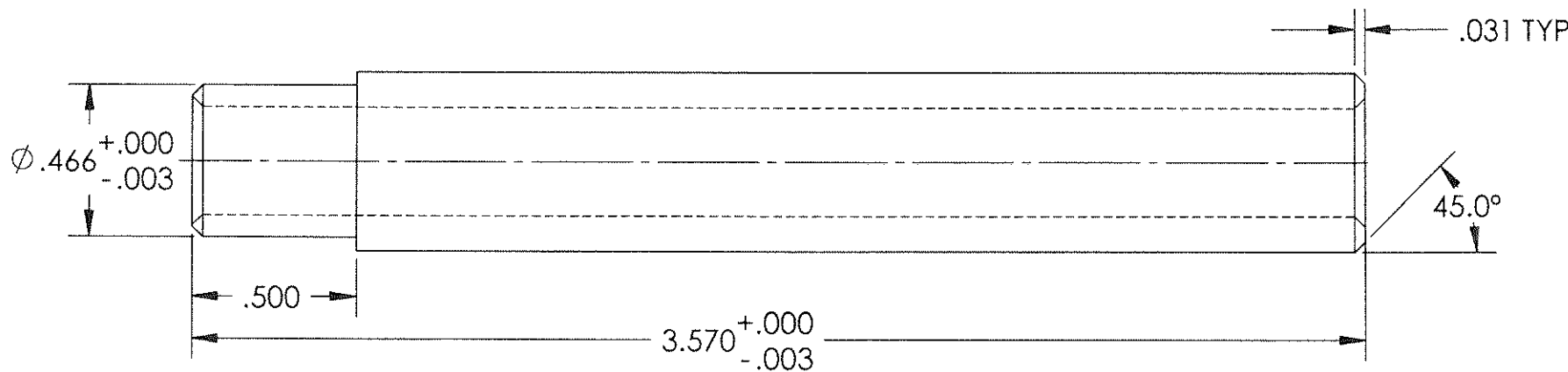
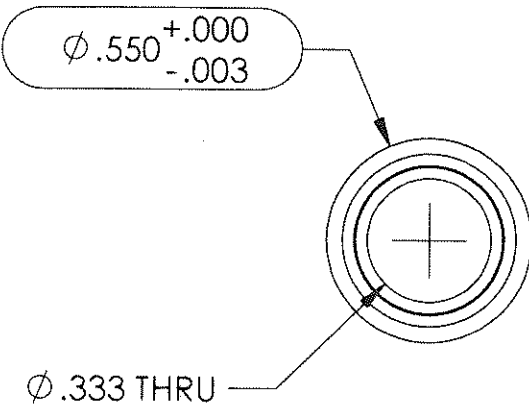
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE B	CAGE CODE 07MZ6
SCALE: NONE		SHEET 14 OF 16	

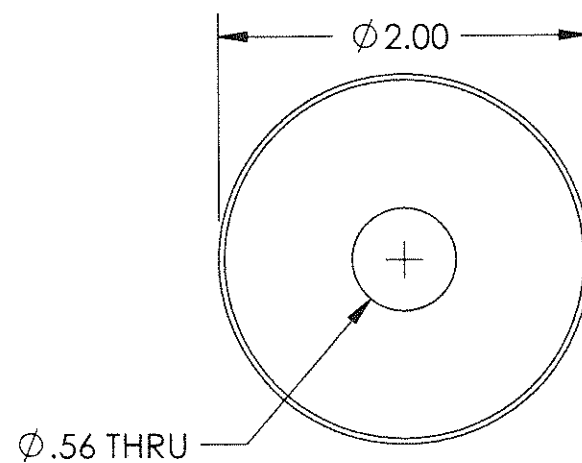
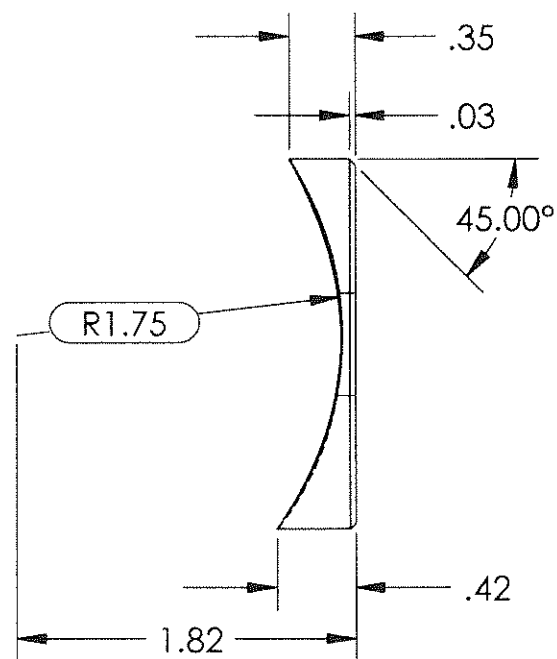
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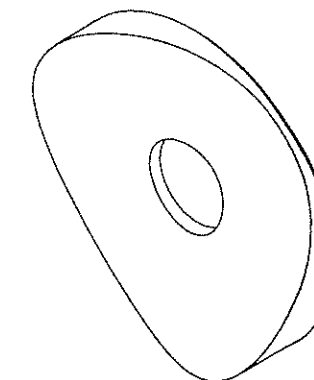
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CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm 5^\circ$		SIZE	CAGE CODE	DWG. NO.	REV.
		B	07MZ6	644.4100	F
		SCALE: NONE			

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DRAWING APPROVAL S. JOSEPH 08-29-05			
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SIZE B	REV. F
		CAGE CODE 07M26	DWG. NO. 644.4100
		SCALE: NONE	
		SHEET 16 OF 16	